

5/24

DART AEROSPACE LTD	Work Order:	23385
Description: Gas Spring	Part Number:	D2807
Dwg: D2807 Rev. B Rev C (Possible)	Qty:	35 34

Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	HA	05.05.20	35
2	PG	Issue P/O: <u>2008080</u> **Note: Do not ship by air** **Allow an extra 7 to 10 business days for shipping** Order as per Dwg D2807 Possible supplier: Spring Lift, P/N SL-4-40 (40 lb load) Material release note is required	LA	05-05-20	35
3	RG	Receive and Inspect for transit damage Ensure the material release note is attached	CL	05/06/08	35
4	QC6	Inspect dimensions as per Dwg D2807 and test spring is 40lb	AD	05.06.10	35
5	FP GA	Open hole as per Dwg D2807 and touch up with paint <small>Assemble as per dwg D2807 Rev.C.</small> <small>Qty (2) D2807-3 Lug BATCH No. 323479</small>	AD	05.06.10	34
6	FP	Mask, prime and paint as per Dwg D2807 using Plasti-Kote "Rust Not" primer and Plasti-Kote "Super Enamel" T1 Gloss Black Plasti-Kote "Rust Not" Batch: Plasti-Kote "Super Enamel" Batch:			
7	QC3	Inspect Paint	CP	05.06.10	34
6	QC5	INSPECT WORK TO STEP 5			
8	PK	Identify and Stock	AD	05.06.10	34
9	AC	Cost / part: <u>36.89</u>	AP	05-06-13	34
10	DC	Close W/O <u>27.30</u> Inspect Level 21	HA	05.06.16	34

PD

Rev	Date	Change	Revised By	Approved
A	00.11.09	New Issue	EC	
B	00.11.15	Added step 6	EC	
C	05.04.28	Reformat; Added Step 6 & 7	KJ/JLM	

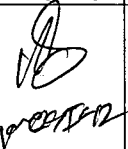

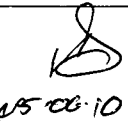
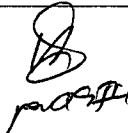
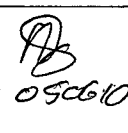
7 GA

Remove brand name & serial number with Acetone

RELEASED
05.06.10 349
05.06.25

perm. chg.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
6							
7							

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-06-10	5	One scrap but creeper		destroy	 05-06-10	 05-06-10	 05-06-10	 05-06-10

Part No: D2807 PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 05/06/10

NOTE: Date & initial all entries

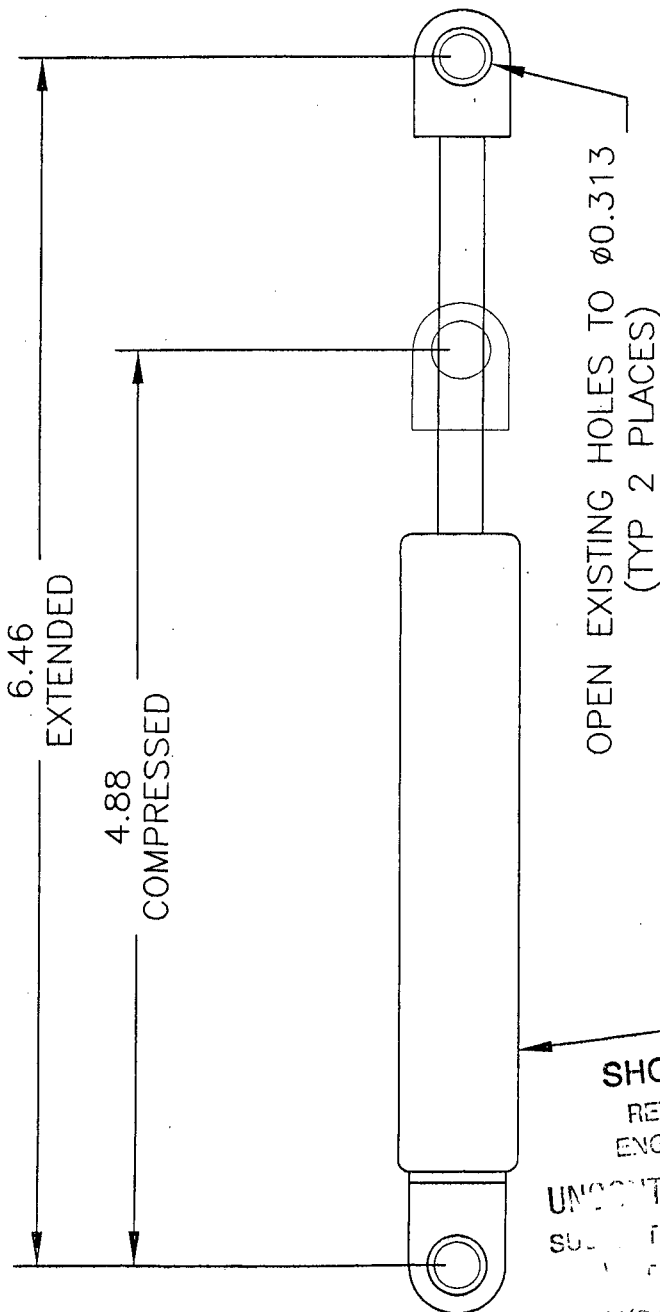
QA: N/C Closed: _____ Date: _____



DESIGN	DS	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2807	REV. B SHEET 1 OF 1
DATE	05.03.16			TITLE GAS SPRING	SCALE 1:1
A	00.11.03			NEW ISSUE	
B	05.03.16			ADD FINISH	

RELEASED

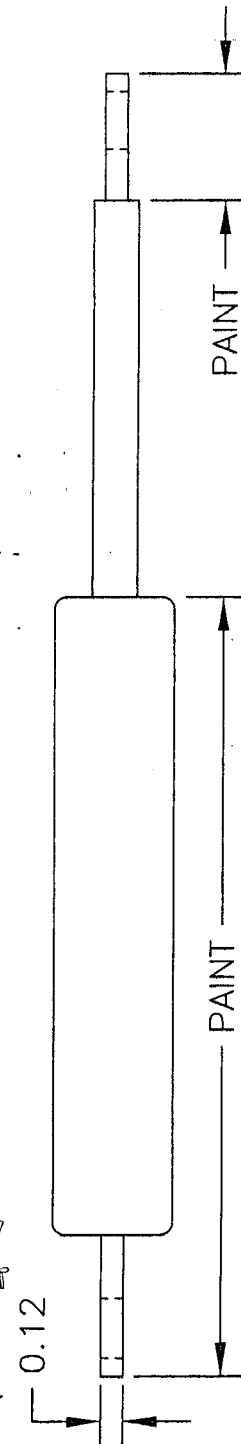
[Signature] 05.03.16



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REVISION NOTICE

WORK ORDER

NO. 23385



D2807 GAS SPRING

- 1) POSSIBLE SUPPLIER: SPRING LIFT P/N: SL-4-40 (40 lb LOAD)
ACCEPTABLE LOAD RANGE IS 25 lb MIN TO 45 lb MAX
- 2) FINISH: AFTER DRILLING, IN AREAS MARKED "PAINT" ABOVE: LIGHTLY SAND AND THEN PRIME
AND PAINT USING PLASTI-KOTE "RUST NOT" 391 GREY PRIMER AND PLASTI-KOTE
"SUPER ENAMEL" T-1 GLOSS BLACK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

May 19, 2005
08:13 am

Work Order No : 0023385
Project Name : D2807
Project For : WK524
Work Order Type : Main
Main WO Number :
House Part Number : D2807
Description : Support Prop
Manufactured : Yes
Amount Req'd : 35
Amount Done : 0
Start Date : 05-19-05
Est Finish Date : 06-20-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

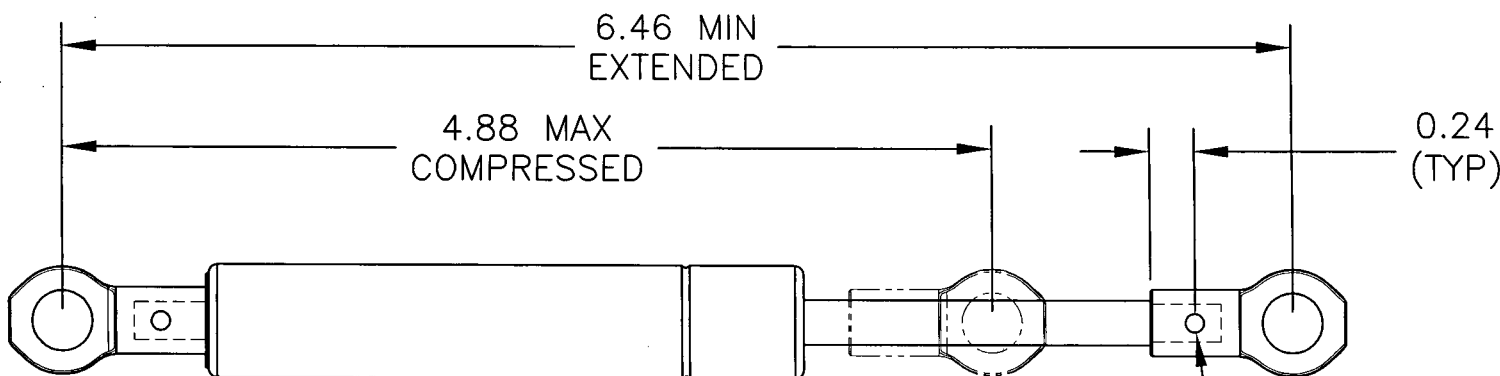
Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

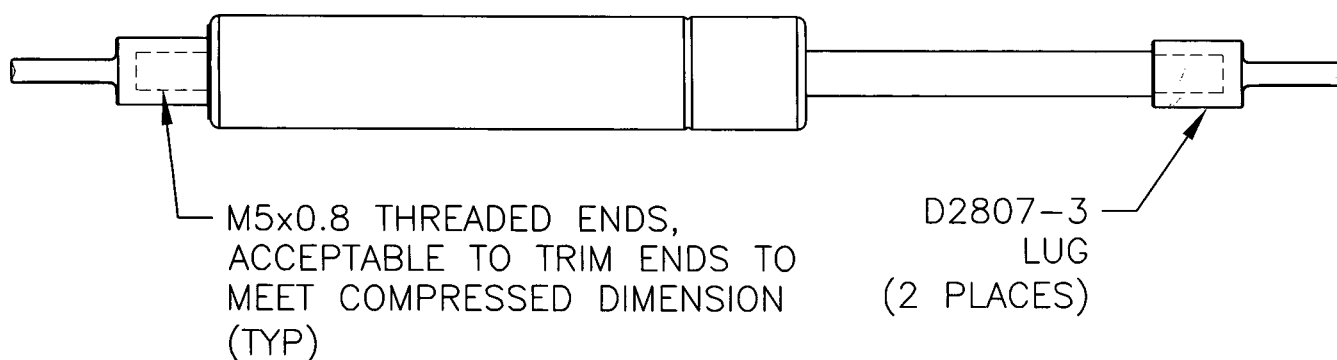
	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

PRELIMINARY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD
DS	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D2807
DATE	TITLE	REV. C
05.05.25	GAS SPRING	SHEET 1 OF 2
A	00.11.03	NEW ISSUE
B	05.03.16	ADD FINISH
C	05.05.25	CHANGE SPRING TO SS, ADD -3 LUG
		SCALE 1:1



Ø0.063 Pos. 16.109
 DRILL ~~#40~~ (~~Ø0.098~~ REF) THROUGH,
 INSTALL 0.020" LOCKWIRE (2 PLACES)



D2807 GAS SPRING

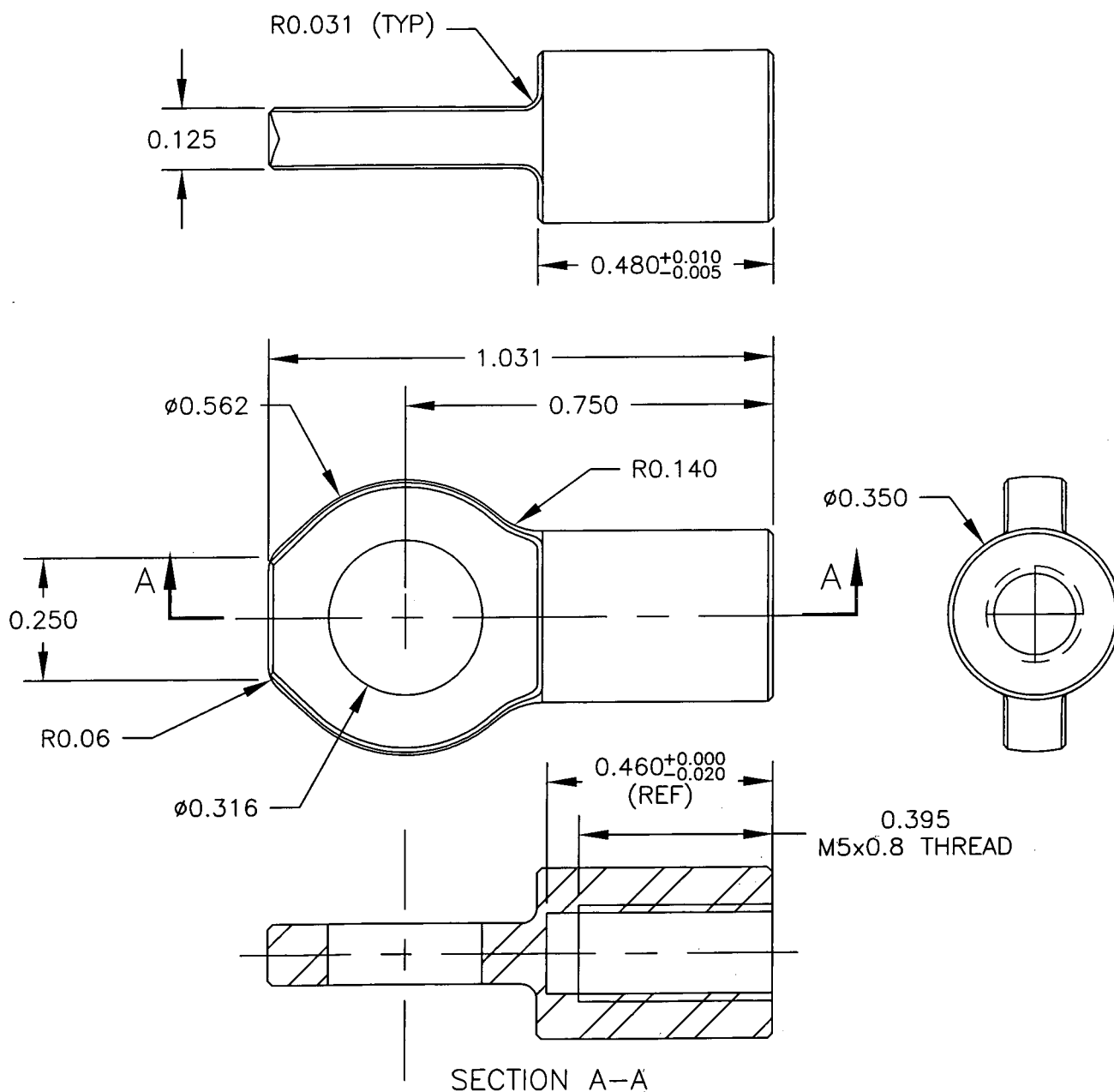
- 1) SPECIFICATION: SS GAS SPRING
 ACCEPTABLE LOAD RANGE IS 25 lb MIN TO 45 lb MAX
 M5x0.8 THREADS

POSSIBLE SUPPLIER: ArvinMeritor Motion Control Systems, Leicester, UK
 P/N: SXF6S6050080S6L-115N
 (REF: 80mm LONG CYLINDER, 50mm STROKE, 115N LOAD)

- 3) ALL DIMENSIONS ARE IN INCHES
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

PRELIMINARY ISSUE

DESIGN DS	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2807	REV. C SHEET 2 OF 2
DATE 05.05.25	TITLE GAS SPRING		SCALE 3:1



D2807-3 LUG

- 1) MATERIAL: AISI 303 ROUND BAR (REF DART SPEC. M303R)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.015
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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